

Work Order ID 51159

August 5, 2009 7:48:29 AM

Page 1

Item ID: D3041-1

Revision ID: C-1

Item Name: Clamp

Start Date: 8/05/09

Start Qty: 30.00

Required Date: 8/10/09

Req'd Qty: 30.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3041

Rev C

100

0.00



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut D2423 Extrusion: 1.250" Long

0.00

DTT 09/08/05

30 0

110

0.00



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine per folio FA153

0.00

DTT 09/08/06

30 0

120

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

DTT 09/08/06

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

SP 09/08/10



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

=> 09-08-10



HandFinish

Memo

0.00

Hand Finishing

(X30)

ely

150

QC5- Inspect part completeness to step on W/O

0.00

=> 09/08/10



QC

Memo

0.00

Quality Control

counted
(X30)

φ

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID 51159

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Item ID: D3041-1

Accept



Setup Start



Revision ID: C-1

Stop



Item Name: Clamp

Start Date: 8/05/09 Start Qty: 30.00



Cust Item ID:

Required Date: 8/10/09 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

1112260

0.00

Powder Coating

Mask inside of 0.8120" diameter hole START TIME:

1.45pm OVEN TEMPERATURE: 2.15pm FINISH TIME: 320°F

=> 09-08-10 x30 JV

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> Sorlosko

count

(x30) ✓

180

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1- Press D2611 bearing into lug as per Dwg D3041 12- Stake bearing into place as per Dwg D3041 ***PLEASE SEE JASON BEFORE PRESSING BEARINGS FOR NEW TOOLING** RE

8/09/08/31 (26)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

Item ID: D3041-1

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Setup Start



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Stop



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Cust Item ID:

Required Date: 8/10/09 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

27 8/09/08/31

counted
(26)

Quality Control

200

Identify as per dwg & Stock Location: 463

0.00



Packaging

Memo

0.00

8/9/08 (26)

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

09/09/08
MF 09-09-08

Quality Control

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

August 5, 2009 7:48:29 AM

Page 1

Work Order ID: 51159

Parent Item: D3041-1RevC-1

Parent Item Name: Clamp



Comments:

Start Date: 8/05/09

Required Date: 8/10/09

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2423RevB1		Manufactured	No			180	f	760.9447	2.6305			
												
Lug Extrusion												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 760.94468

43722 213.01468

44529 22.39

45800 525.54

D2611RevC

Manufactured No

100 Each

37.0000 30.0000



Bearing



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 37

46841 8

50521 29

B 51262

3.125(F) DT 8/8/09

EP 09/08/31

26

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 51159
Description: CLAMP		Part Number: D3041-1
Inspection Dwg: D3041 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

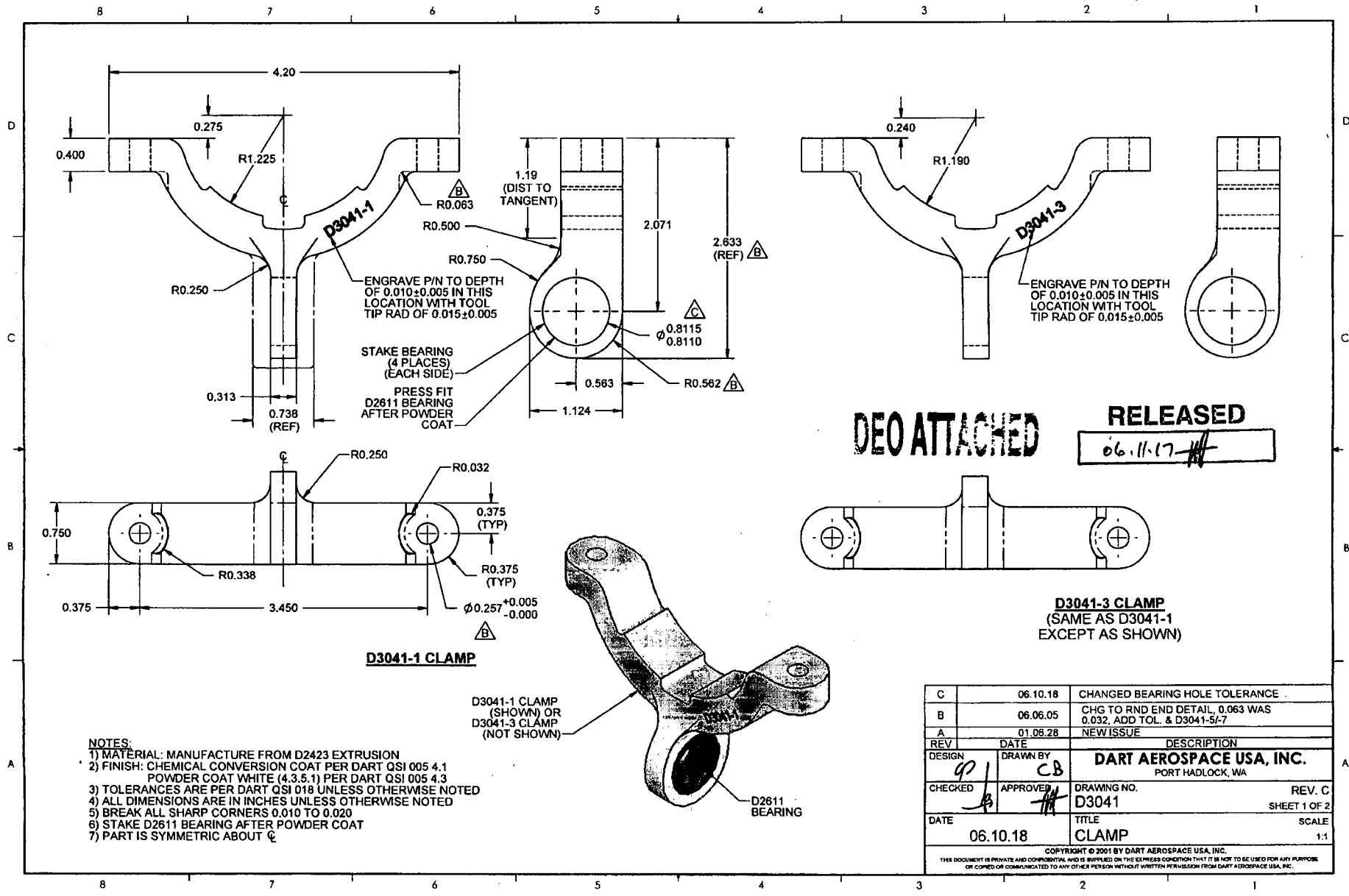
☒ First Article ☐ Prototype

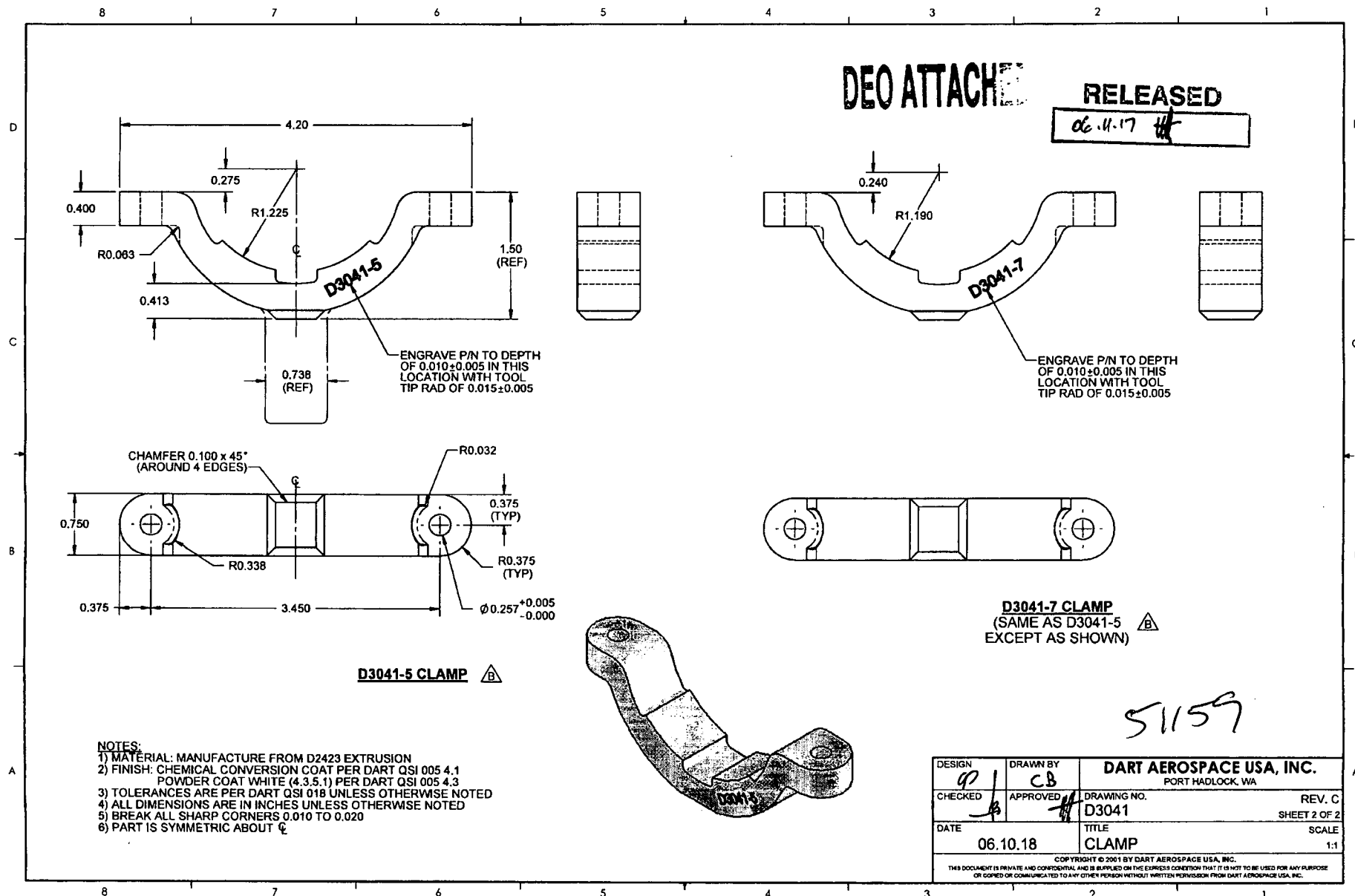
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	±0.030	4.203	✓			
0.275	±0.010	0.275	✓			
0.400	±0.010	0.393	✓			
R1.225	±0.010	1.225	✓			
RO.250	±0.010	0.250	✓			
0.313	±0.010	0.310	✓			
RO.063	±0.010	0.063	✓			
RO.500	±0.010	0.500	✓			
RO.750	±0.010	0.750	✓			
1.124	±0.010	1.128	✓			
0.563	±0.010	0.567	✓			
RO.562	±0.010	0.562	✓			
Ø0.811	+0.005/-0.0000	0.811	✓			
2.633	±0.010	2.6345	✓			(REF)
2.071	±0.010	2.073	✓			
0.750	±0.010	0.753	✓			
0.375	±0.010	0.377	✓			(TYP)
3.450	±0.010	3.447	✓			
Ø0.257	+0.006/-0.001	0.258	✓			
RO.375	±0.010	0.375	✓			(TYP)
RO.032	±0.010	0.032	✓			
RO.250	±0.010	0.250	✓			

Measured by: DJP	Audited by: [Signature]	Prototype Approval:	N/A
Date: 09/08/06	Date: 09/08/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

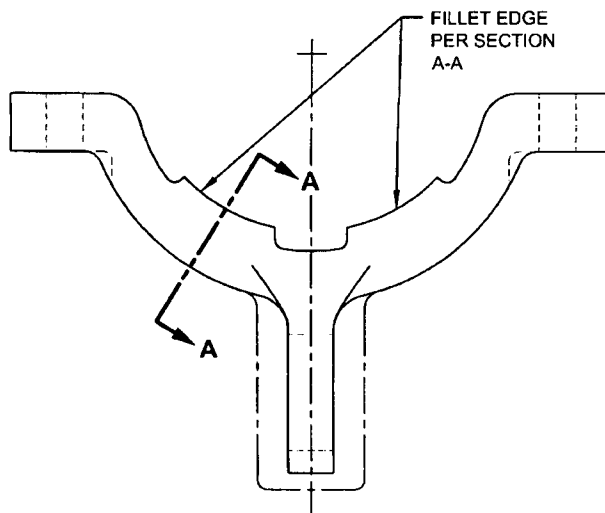
4051159





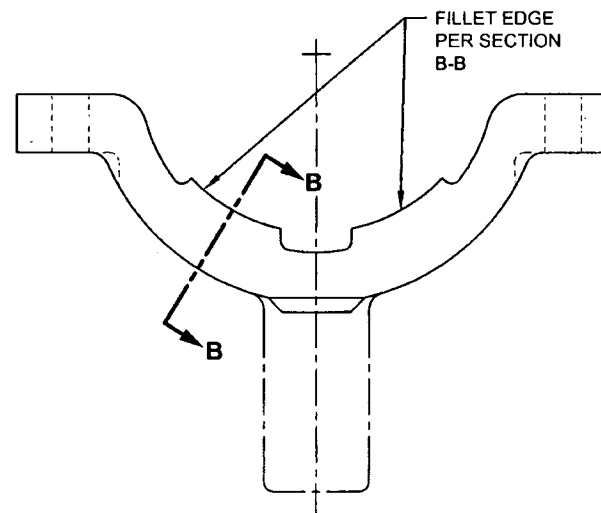
DRAWING NO. D3041	TITLE CLAMP	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3041-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN ADS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 09.03.04	DATE 09.03.12	DATE 09.03.12	DATE 09.03.13		DATE 09.03.13		

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



D3041-1 CLAMP

D3041-3 CLAMP



D3041-5 CLAMP

D3041-7 CLAMP



R0.060 MIN - R0.10 MAX
2PL

SECTION A-A

SCALE 2X

SECTION B-B

SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

RELEASED
09/07/07

51159

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